

# Work Order ID 60915

Monday, July 26, 2010 3:31:34 PM

Page 1



Item ID: D2989-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*H*

Date: 10-7-24

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

0.00

100



Large Fab

Large Fab

Large Fab

Memo

1- pick D3166-3 to cut D2989-13 rib as per dwg D2989 using DT9443 jig 2-  
remove identification markings 3- deburr

0.00

SAD 10-08-11

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8.10.08.11

4

13

120



Packaging

Packaging

Identify as per dwg & Stock Location: WA

Memo

0.00

0.00

SAD

10-08-11

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60915

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Page 2

Item ID: D2989-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/08/11  
cmf  
10-8-11

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 60915

Parent Item: D2989-13

Parent Item Name: Rib



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3

Manufactured No

100

Each

10.5682

0.18

0.757895



Basket Hoop

## Location

WA

55697

59266

60270

## Loc Qty

10.56822105

2.1053E-05

4.5682

6

## Loc Code



SAD 10-08-11

0.7579

W/O:		WORK ORDER CHANGES					
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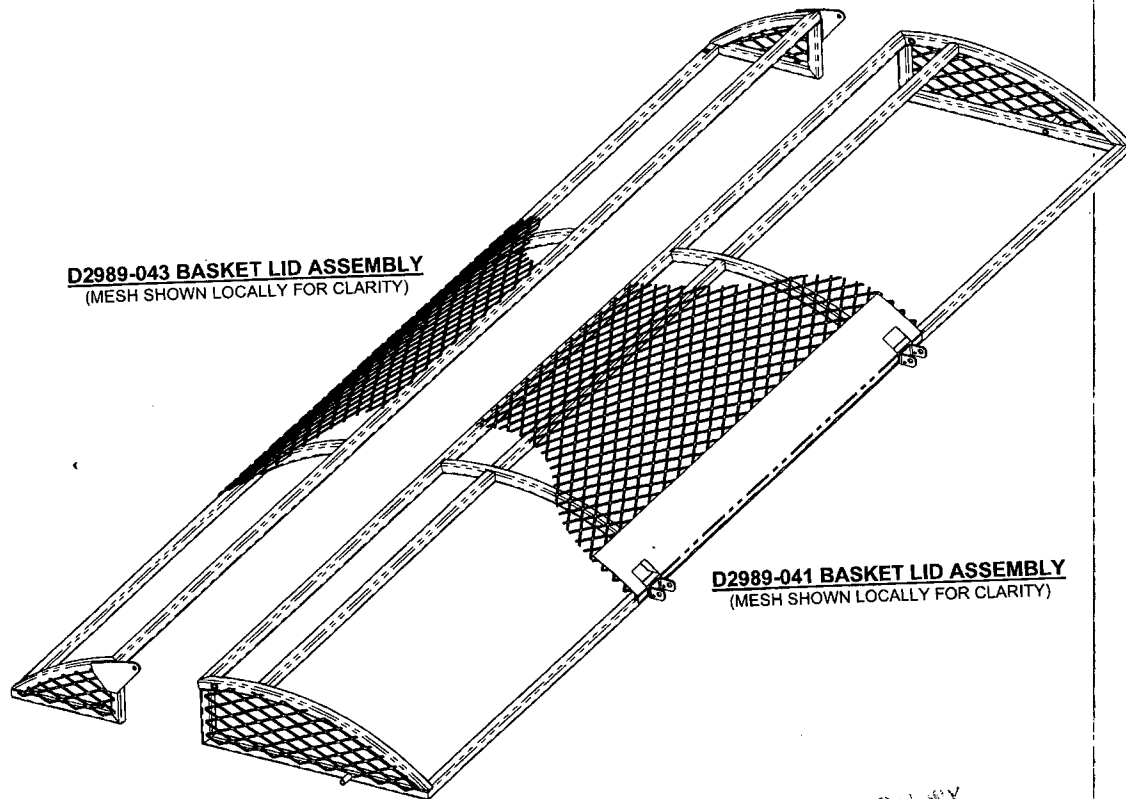
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**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

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WITHOUT NOTICE  
WORK ORDER  
NO. 10915  
13810-7-26

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9-15; D3836-042 REPLACES D2989-10-15; D3838-041 REPLACES D2989-1-7; D3838-042 REPLACES D2989-2-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED	AJS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2989**  
REV. D  
SHEET 1 OF 5  
SCALE  
NTS

TITLE **BASKET LID ASSEMBLY**  
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

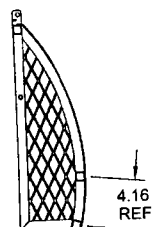
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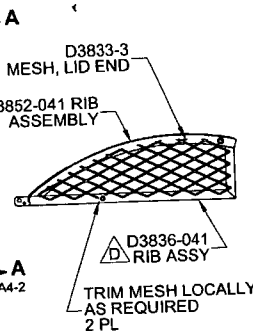


# SECTION B-B



4.16  
REF

D7-2



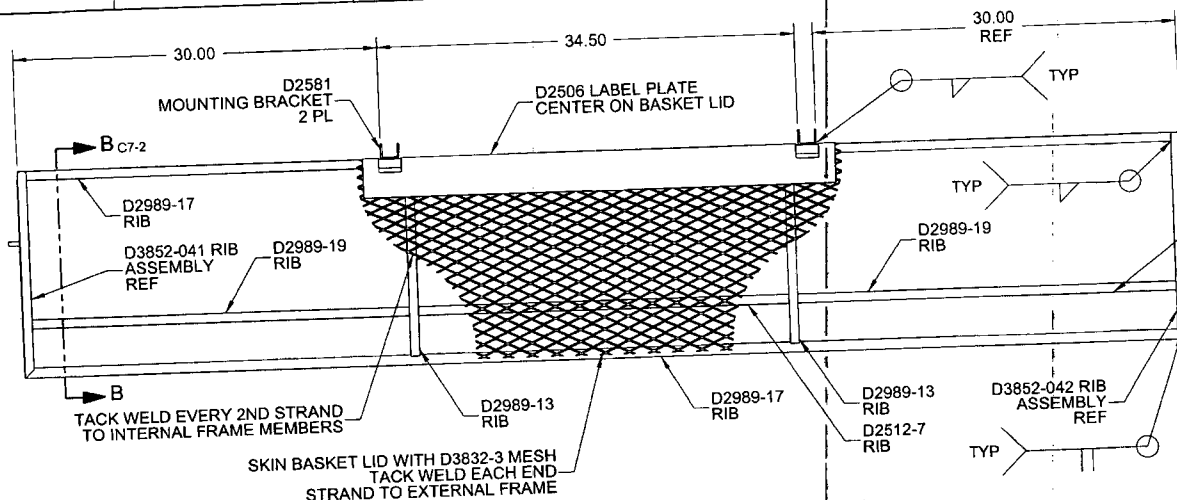
D3833-3  
MESH, LID END

D3852-041 RIB  
ASSEMBLY

D3836-041  
RIB ASSY

TRIM MESH LOCALLY  
AS REQUIRED  
2 PL

A4-2



D2581  
MOUNTING BRACKET  
2 PL

D2506 LABEL PLATE  
CENTER ON BASKET LID

B C7-2

D2989-17  
RIB

D3852-041 RIB  
ASSEMBLY REF

D2989-19  
RIB

TACK WELD EVERY 2ND STRAND  
TO INTERNAL FRAME MEMBERS

SKIN BASKET LID WITH D3832-3 MESH  
TACK WELD EACH END  
STRAND TO EXTERNAL FRAME

D2989-13  
RIB

D2989-17  
RIB

D2989-13  
RIB

D2512-7  
RIB

D3852-042 RIB  
ASSEMBLY REF

TYP

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID  
PAINT THIS SECTION

TACK WELD MESH TO LABEL PLATE  
AT EVERY AVAILABLE LOCATION

D2989-13 RIB  
REF

D2989-13 RIB  
REF

31.94

32.13  
REF  
96.00  
REF

31.94

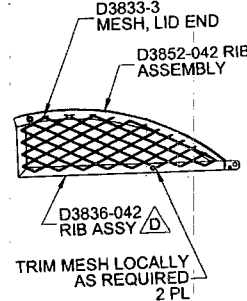
**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



2 PL

FILL NOTCH  
WITH WELD  
9 PL

**VIEW A:A** B8-2



D3833-3  
MESH, LID END

D3852-042 RIB  
ASSEMBLY

D3836-042  
RIB ASSY

TRIM MESH LOCALLY  
AS REQUIRED  
2 PL

**RELEASED**  
08/11/18/19

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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*w/c 6 09/13*

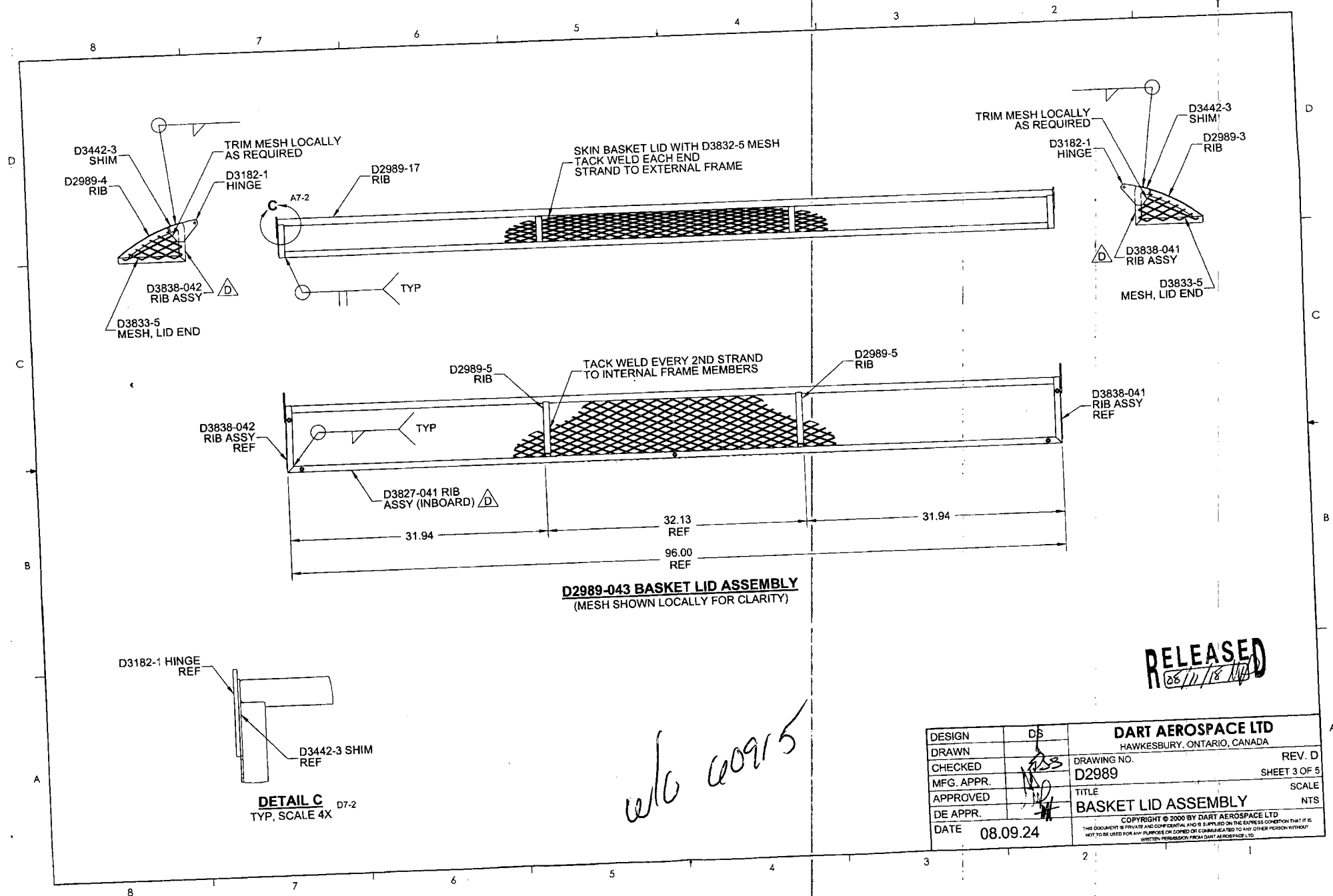
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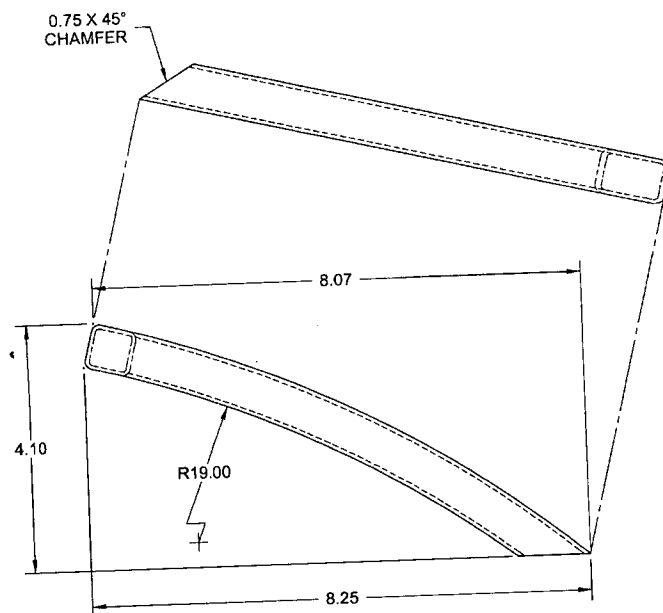
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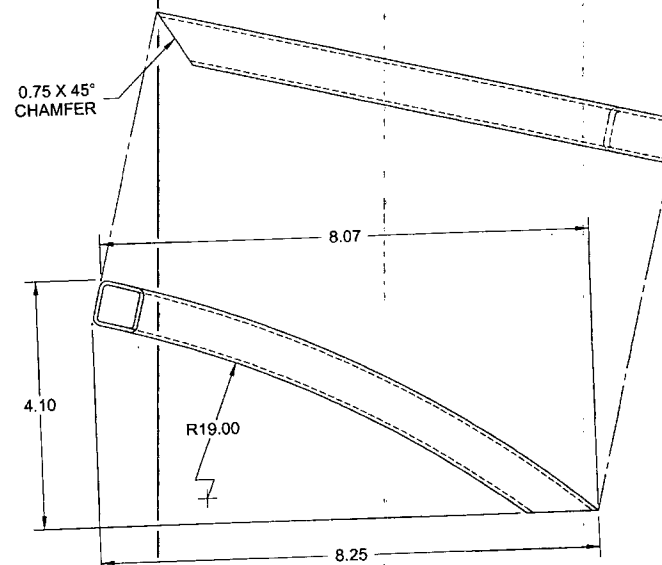
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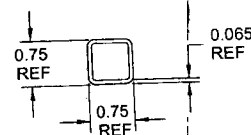
**NOTE:** Date & initial all entries



**D2989-3 RIB**



**D2989-4 RIB**



**TYPICAL SECTION  
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 4 OF 5
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*u/o 60915*

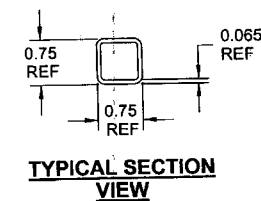
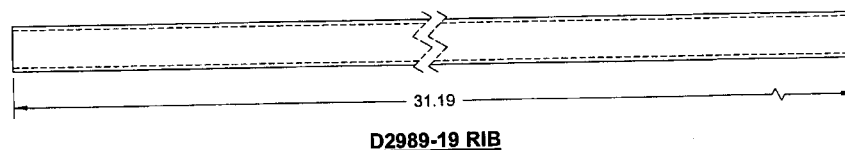
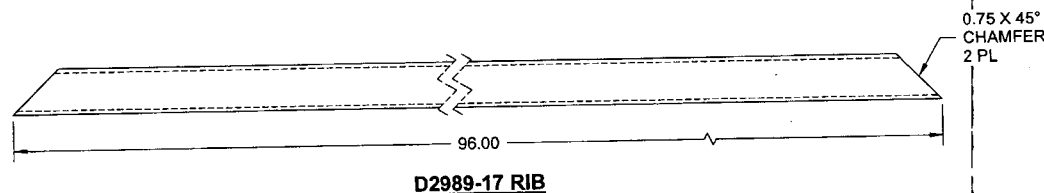
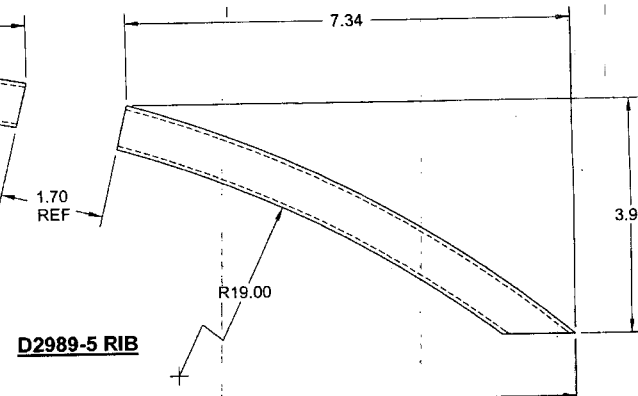
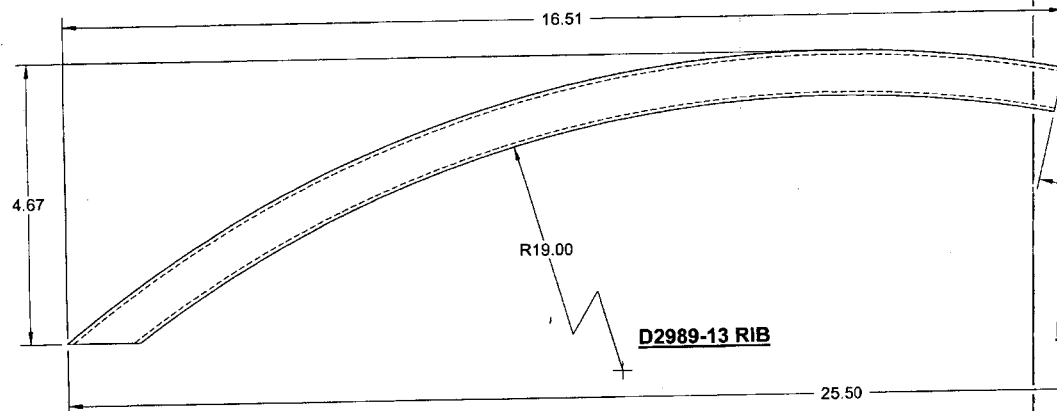
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

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WORK ORDER

NO. 60916

BR10-7-26

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CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
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